

Date: Friday, 30/05/2008 10:56:24 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 39609

Estimate Number : 13306


P.O. Number :

This Issue : 30/05/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 30/05/2008 Type : R & D SM/MED FAB

Previous Run :

Written By : Checked & Approved By : 

Comment : Est rev A 08.05-12 new issue DD verified by:

Drawing Name : AFT FACING SEAT ASSY LH **FOR ENGINEERING USE ONLY**

Part Number : D412769041

Drawing Number : D412-769-041 PROTO

Project Number : N/A

Drawing Revision : PROTO

Material :

Due Date : 06/06/2008 Qty: 1 Um: Each

Additional Product

PROTOTYPE

Job Number:




Seq. #: Machine Or Operation: Description :


1.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit


2.0 D3782045 Back Leg Assembly

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Back Leg Assembly
batch: B39649  080603


3.0 D3782041 Front Inboard Leg Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Front Inboard Leg Assembly
batch: B05014  080603

4.0 D3782043 Front Outboard Leg Assembly, LH

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Front Outboard Leg Assembly, LH
batch: B05013  080603

5.0 D3783041 Lateral Brace Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Lateral Brace Assembly
batch: B05005  080603

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Part Number: D412769041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3783043

Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Longitudinal Brace Assembly
batch: B05006

70

080603

7.0

D3783045

Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Angle Brace Assembly
batch: B05007

70

080603

8.0

D3784041

Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, Center
batch: B05010

70

080603

9.0

D3784043

Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, LH
batch: B05009

70

080603

10.0

D3784044

Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, RH
batch: B05008

70

080603

11.0

D37661

Front Rail, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Front Rail
batch: B38868

70

080603

12.0

D37663

Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rear Rail
batch: B38874

70

080603

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Part Number: D412769041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D37671

Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: B38866

Handwritten signature

080603

14.0

D37921

Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: _____

use BHT P/N 205-070-725-011

Handwritten signature

080603

15.0

AN45 13A

EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M107938

Handwritten signature

080603

16.0

AN515A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

batch: M108077

Handwritten signature

080603

17.0

AN510A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M107013

Handwritten signature

080603

18.0

AN513A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M107321

Handwritten signature

080603

19.0

NAS1149F0563P

Washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Washer

batch: M108099

Handwritten signature

080603

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 39609

Part Number: D412769041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

NAS1149F0463P

Washer



AN960-416



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M5519

JA

080603

21.0

MS21042L5

Nut



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Nut

batch: M107 464

JA

080603

22.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M107478

JA

080603

23.0

AN415A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M107737

JA

080603

24.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-041

JA

080604

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

26.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-mask D3787-1 foot and around area of red powder coat as per dwg D412-769-041

2-Powder coat only D3782-041 and D3782-043 front legs in red as per dwg D412-769-041

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

100

Date: Friday, 30/05/2008 10:56:25 AM
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Process Sheet

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 39609

Part Number: D412769041

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

27.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

28.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-041

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

29.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

D37741

Seat Bottom, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: _____

32.0

D37743

Seat Back, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: _____

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Job Number: 39609

Part Number: D412769041

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN52510R24

Screw



AN52510R22



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

batch: M107936

✱

080604

34.0

NAS1149F0363P

Washer



AN960-10



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Washer

batch: m 5519

✱

080604

35.0

MS21042L3

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

batch: M107644

✱

080604

36.0

AN35A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M100188

✱

080604

37.0

D412724041

Head Rest Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, Center

batch: ~~B38957~~ B38956

✱

080604

38.0

D412724043

Head Rest Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, LH

batch: B38957

✱

080604

39.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-041

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 39609

Part Number: D412769041

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

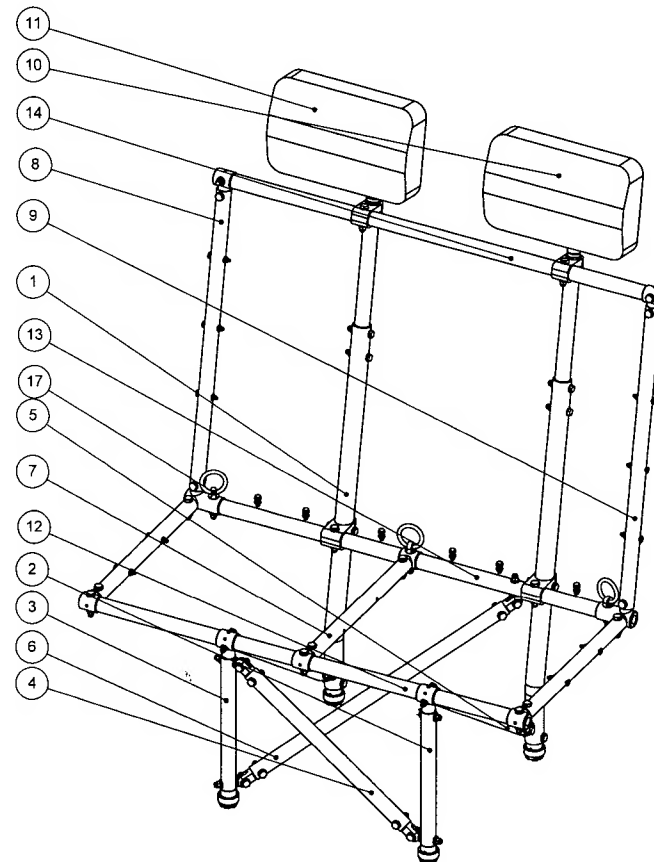
Job Completion



change to W/O #0096

u 08.06.11

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D412-724-041	HEAD REST ASSY, CENTER	1
11	D412-724-043	HEAD REST ASSY, LH	1
12	D3766-1	FRONT RAIL, LH	1
13	D3766-3	REAR RAIL	1
14	D3767-1	UPPER RAIL	1
15	D3774-1	SEAT BOTTOM, LH	1
16	D3774-3	SEAT BACK, LH	1
17	D3792-1	SEAT BELT EYE BOLT	3
18	AN45-13A	EYE BOLT	1
19	AN5-10A	BOLT	6
20	AN5-13A	BOLT	2
21	AN5-15A	BOLT	9
22	AN4-15A	BOLT	2
23	AN3-5A	BOLT	6
24	AN525-10R24	SCREW	10
25	MS21042L3	NUT	16
26	MS21042L4	NUT	2
27	MS21042L5	NUT	21
28	NAS1149F0363P	WASHER	22
29	NAS1149F0463P	WASHER	4
30	NAS1149F0563P	WASHER	38

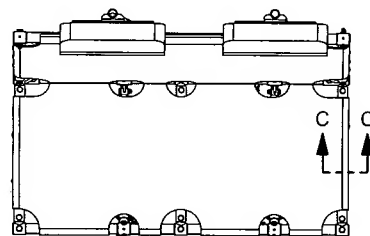


QTY x1 D412-769-041 AFT FACING SEAT ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3) AND HEADRESTS (D412-724-041/-043). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK OF SEAT BACK
- 7) WEIGHT: 42.67 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM, LH) AND ITEM 16 (D3774-3 SEAT BACK, LH) REMOVED FOR CLARITY

A	NEW ISSUE	HS	08.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D412-769-041	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
DATE	08.05.28	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



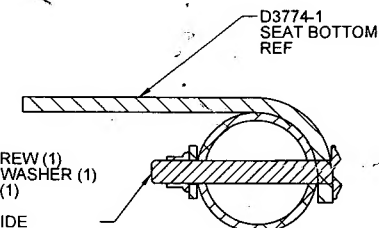
AN525-10R24 SCREW (1)
NAS1149F0363P WASHER (1)
MS21042L3 NUT (1)
TYPICAL
3 PLACES PER SIDE

D3774-3
SEAT BACK
REF

1

D3784-044
SEAT SUPPORT, RH
REF

SECTION A-A

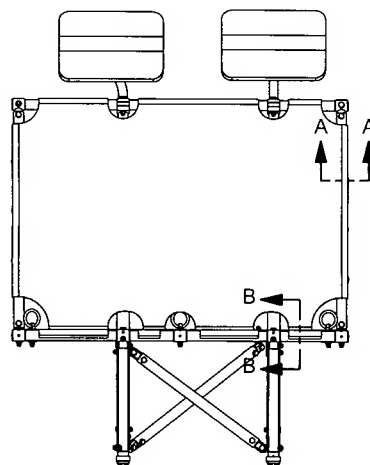


D3774-1
SEAT BOTTOM
REF

2

D3784-044
SEAT SUPPORT, RH
REF

SECTION C-C



D3766-1
FRONT RAIL
REF

SECTION B-B

D3774-3
SEAT BACK
REF

D3774-1
SEAT BOTTOM
REF

D3766-3
REAR RAIL
REF

3

AN3-5A BOLT (1)
NAS1149F0363P WASHER (2)
MS21042L3 NUT (1)
TYPICAL
6 PLACES

- NOTES:
- 1) TRANSFER DRILL $\varnothing 0.188$ FROM SEAT SUPPORT (D3784-044) TO SEAT BACK (D3774-3) - 3 PLACES
 - 2) TRANSFER DRILL $\varnothing 0.188$ FROM SEAT SUPPORT (D3784-044) TO SEAT BOTTOM (D3774-1) - 2 PLACES
 - 3) TRANSFER DRILL $\varnothing 0.188$ FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PLACES

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D412-769-041	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
DATE	08.05.28	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMERCE OR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	